

~~Re-Print~~

Work Order ID 119324

119324

Page 1

July-03-15 8:26:38 AM

Item ID: D3197-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bar

Start Date: 15/05/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 15/05/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: 15-0703 Date: _____

Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3197	Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

6 0 15/07/03

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Deburr

6 0 15-7-6

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

6 0 15-7-6

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[illegible]

Work Order ID 119324

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Item ID: D3197-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 15/05/2014 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 15/05/2014 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	M 130746, Grey Sandtex (Ref 4.3.5.6) per QSI005 4.3 M 130746 Memo START TIME: 8:25 FINISH TIME: 8:55	0.00 0.00				6	6	15-7-21	
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				6	FF	JUL 21 2015	
180 *180* Small Fab Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.00				6	FF	JUL 21 2015	

DAS 34 9-89

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July-03-15 8:26:38 AM

Item ID: D3197-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Bar
 Start Date: 15/05/2014 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 15/05/2014 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>6</u>			DAS 38 9-89 JUL 2 1 2015
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>5/286</u> Memo	0.00 0.00			DAS 27 9-89	<u>6</u>			JUL 2 1 2015
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							MLJ JUL 2 1 2015 Hay 15/7/21. MLJ JUL 2 1 2015

Picklist Print

July-03-15 8:26:36 AM

Page 1

Work Order ID: 119324

119324

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 15/05/2014

Required Date: 15/05/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2690-5		Manufactured	No			180	Each	18.0000	2	12			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D2690-5

Lanyard Assembly

**

FF

JUL 21 2015

Location

Loc Qty

Loc Code

ST012a

18

119601

12

124411

6

D3242-1		Manufactured	No			180	Each	22.0000	2	12			
---------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3242-1

Tag

**

FF

JUL 21 2015

Location

Loc Qty

Loc Code

GA

22

119565

2

129592

20

D3489-3-200		Manufactured	No			180	Each	13.0000	2	12			
-------------	--	--------------	----	--	--	-----	------	---------	---	----	--	--	--

D3489-3-200

Pip Pin

**

FF

JUL 21 2015

Location

Loc Qty

Loc Code

GA

13

119335

10

120097

3

M7075T73R1.000		Purchased	No			180	f	52.6800	2.42	19			
----------------	--	-----------	----	--	--	-----	---	---------	------	----	--	--	--

M7075T73R1 000

7075-T73 Rd Bar 1.00

**

15/07/03

Location

Loc Qty

Loc Code

MAT018

52.68

m127647

52.68

14,643

Picklist Print

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Work Order ID: 119324

119324

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 15/05/2014

Required Date: 15/05/2014

Start Qty: 6.00

Required Qty: 6.00

MS21042L3

Purchased

No

180

Each

1,618.000

2

12

MS21042L3

**

FF

JUL 21 2015

Nut

Location

Loc Qty

Loc Code

FP001

393

M130922

393

GA

440

M131317

440

12

ST305

785

116549

12

126333

49

M128754

2

M132123

17

M132382

705

MS27039-1-24

Purchased

No

100

Each

55.0000

2

12

MS27039-1-24

**

FF

JUL 21 2015

Screw

Location

Loc Qty

Loc Code

ST284

55

m127432

55

12

Picklist Print

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Work Order ID: 119324

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Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 15/05/2014

Required Date: 15/05/2014

Start Qty: 6.00

Required Qty: 6.00

NAS1149D0363J

Purchased

No

180

Each

1,303.000

6

36

NAS1149D0363.I********FF****JUL 21 2015**

Washer

LocationLoc QtyLoc Code

CA

132677
m130799

569

569

GA

m128429

134

134

ST269

2799

600

4

6140

8

m126319

7

m131618

17

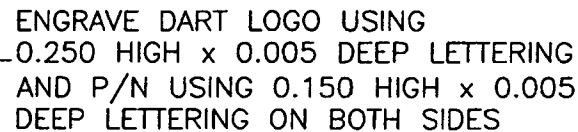
m132317

564

36

06.03.21 UP
per EGN 302

DART



D3197-1 BAR

- | | | | | | |
|----------|---|----------|---|--|--------------|
| DESIGN | CP | DRAWN BY | CP | DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | APPROVED |  | DRAWING NO. | REV. B |
| | | | | D3197 | SHEET 1 OF 1 |
| DATE | | | | TITLE | SCALE |
| 06.01.10 | | | | BAR | 1:1 |
| A | 03.07.01 | | | NEW ISSUE | |
| B | 06.01.10 | | | CHG PIP PIN; ADD D3242-1 TAG | |

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DART AEROSPACE LTD		Work Order: 119324
Description: Bar		Part Number: D3197-1
Inspection Dwg: D3197 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	/		M-TAPE	SL-8
25.06	+/-0.030	25.06	/			
11.44	+/-0.030	11.440	/		Vern	CNC-02
0.500	+/-0.010	500	/			SL-10
0.250	+/-0.030	249	/			
Ø0.219	+0.005/-0.000	220	/			
Ø0.191	+0.005/-0.000	191	/			
1.000	+/-0.005	1.000	/			
2.69	+/-0.030	2.689	/			
1.000	+/-0.010	1.000	/			
0.300	+/-0.010	300	/			
0.063 x 45°	+/-0.010	06 X 45°	/			
Ø1.000	+/-0.010	999	/			

Measured by: SL	Audited by: B.A. DAS	Prototype Approval:	N/A
Date: 15-7-06	Date: 15/07/08 08 9-89	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3197-041)	KJ/JLM	
B	07.03.09	Dwg revision update	KJ/JLM	BE